

Date: Wednesday, 3/29/2006 6:56:59 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEB
Job Number	: 26385		
Estimate Number	: 10498		
P.O. Number	: N/A	Part Number	: D2739
This Issue	: 3/29/2006 S.O. No. : N/A	Drawing Number	: D2739 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LANDING GEAR	Drawing Revision	: C
Previous Run	: 26207	Material	: N/A
Written By	: SEE COMMENT BELOW	Due Date	: 4/5/2006
Checked & Approved By	: <u>W</u>	Qty:	21/8 Um: Each
Comment	: Est Rev: C 02.11.28 Reformat KJ Est Rev: D 06-03-21 As Per Rev C JLM		

Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
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1.0	D26005108	Extrusion 'I Beam' thin
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Extrusion 'I Beam' thin

Pick:

Qty Part Number Description Batch

1 D2600-5 Web 324410 21

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-5 to length as per Dwg D2739 06-03-29 21

2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739 06-03-30 21

3-Use uni-bit to open holes to finish size as per Dwg D2739 06-03-30 21

4-Bevel Fwd ends (1" max) of extrusion and Deburr holes and ends 06-03-30 21

5-Deburr 06-03-30 21

6-Use a red or black lead-free paint pen to write the part number and batch number in the middle of each web.

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 2 Date: 06/04/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

IT 06-04-01 (18)

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

IT 06-4-3 (18)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location

LT IT 06-4-3 (18)

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

IT 06/04/04

Job Completion



LT 06-04-04

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
dc-0257

Technical drawing of a mechanical part, showing a side view and a detail view.

Side View Dimensions:

- Total length: 78.76
- Left end section diameter: $\phi 1.00$ (17 PLACES)
- Central section diameter: $\phi 1.125$
- Right end section diameter: $\phi 1.25$
- Section diameters and counts:
 - $\phi 0.750$ (2 PLACES)
 - $\phi 0.625$ (2 PLACES)
 - $\phi 0.750$ (2 PLACES)

Detail View (DETAIL A):

- Section diameter: $\phi 1.125$
- Section thickness: 1.180
- Number of holes: 8
- Hole diameter: $\phi 0.750$

1) MATERIAL: MAKE FROM D2600--5 EXTRUSION
2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
3) ALL DIMENSIONS ARE IN INCHES
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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